

Date: Tuesday, 11/6/2007 1:13:27 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 35545	
Estimate Number : 13061	
P.O. Number : <i>N/A</i>	Part Number : D32459
This Issue : 11/6/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3245 REV B
Prsht Rev. : <i>NO</i>	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/12/2007 Qty: 8 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est B 04.12.06 Made in-house KJ/JLM	
Est Rev:C ecn 1052/water jet 07-11-05 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3245	Gasket
-----	-------	--------



Comment: Qty.: 0.0426 sf(s)/Unit Total : 0.3410 sf(s)

GASKET

Batch: *B 31158* *FB 07-11-8*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3245

Dwg Rev: *B*Prog Rev: *B**FB 07-11-8**(8)*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

*FB 07-11-8*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6/9/11/08 (8) routes

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST183**AS 07/11/12 (8) [Signature]*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/11/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/6/2007 1:13:27 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 35545

Part Number: D32459

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



8

Comment: FINAL INSPECTION/W/O RELEASE

AD 07/11/12

Job Completion



W 07.11.12

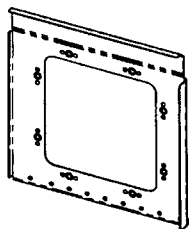
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

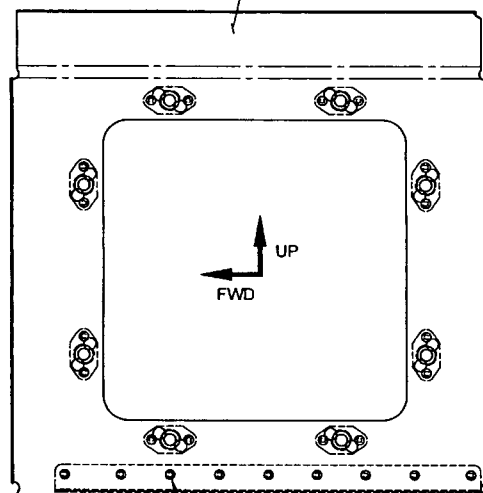
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



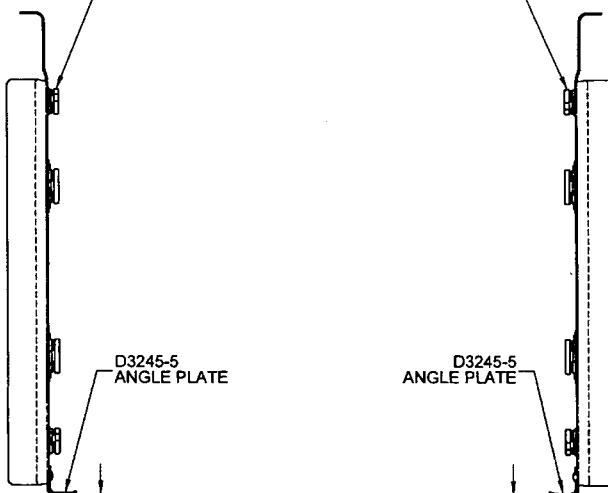
D3245-1
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



MS20615M3-3 RIVET
(9 PLACES)

D3245-041 ACCESS PANEL ASSEMBLY



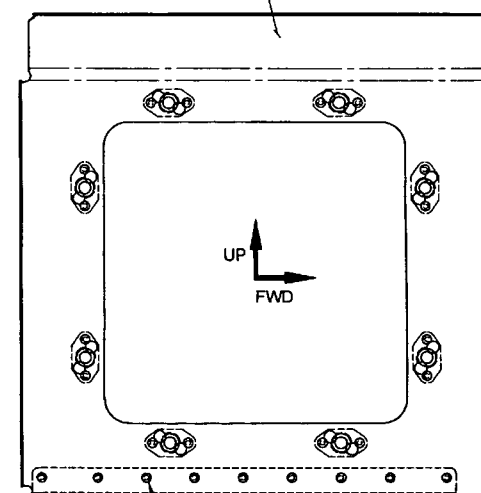
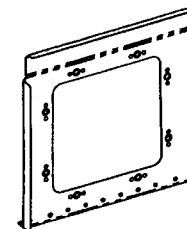
0.032
GAP

D3245-5
ANGLE PLATE

D3245-5
ANGLE PLATE

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-2
PANEL



MS20615M3-3 RIVET
(9 PLACES)

D3245-042 ACCESS PANEL ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

RELEASED
07-10-23

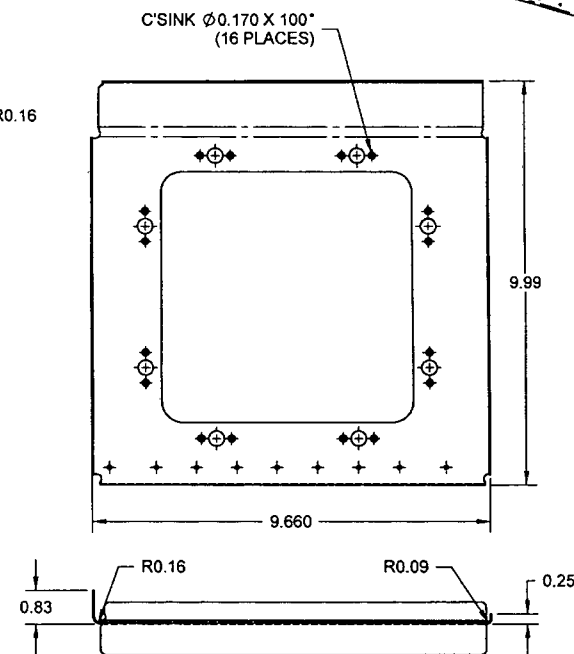
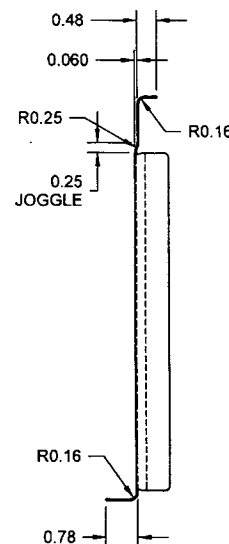
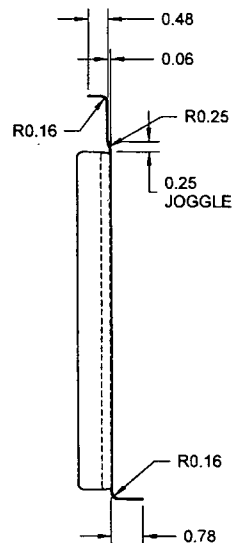
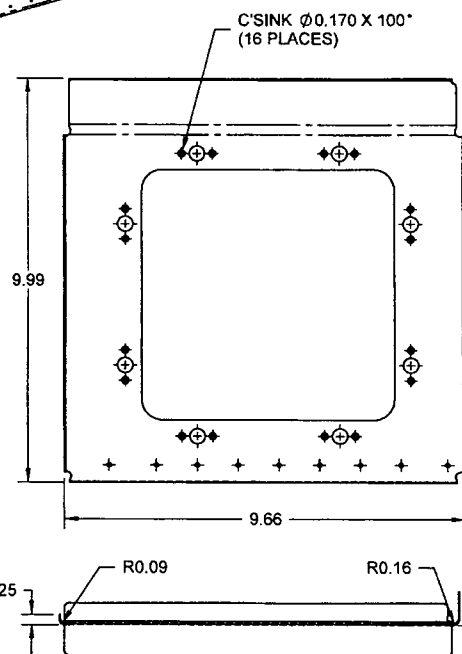
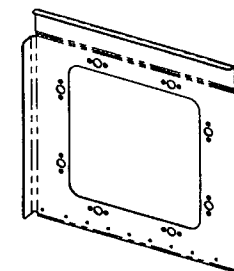
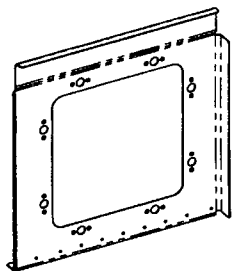
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

B	REMOVE Ø0.204 HOLES FROM D3245-1/-1F, REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.02		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3245	REV. B
TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2.5
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338245



D3245-1 PANEL BEND DETAIL, LH

D3245-2 PANEL BEND DETAIL, RH

RELEASED
27-10-23

- NOTES:
 1) MATERIAL: MAKE FROM D3245-1F
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.70 lbs

DESIGN	71	DART AEROSPACE LTD	
DRAWN	JH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3245	SHEET 2 OF 7
APPROVED	140	TITLE	SCALE
DE APPR.	140	ACCESS PANEL ASSEMBLY	1:3
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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 WITHOUT NOTICE

8 7 6 5 4 3 2 1

D3245-5 DOOR
2351-20-009-C3Y STUD (1)
127H-35 GROMMET (1)
(8 PLACES)

D3245-7 GASKET
(REF)

8.00
(TYP, REF)

D3245-043 DOOR ASSEMBLY

INSTALL D3245-7
GASKET ON THIS SIDE

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

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APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY	
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(7/17/02)

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7 6 5 4 3 2 1

8

7

6

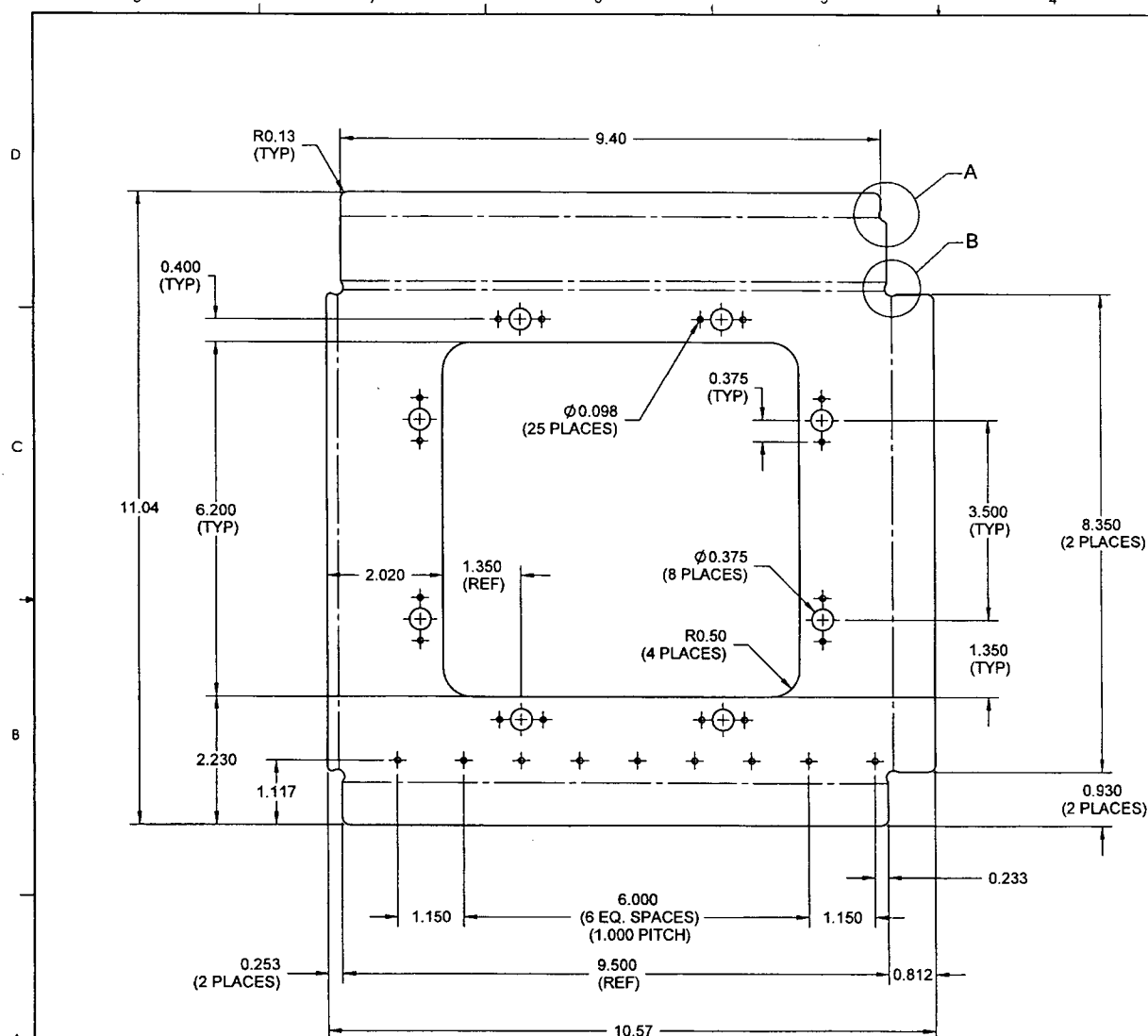
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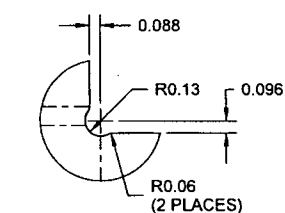
3

2

1



DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
(TYP. 4 PLACES)
SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
(0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

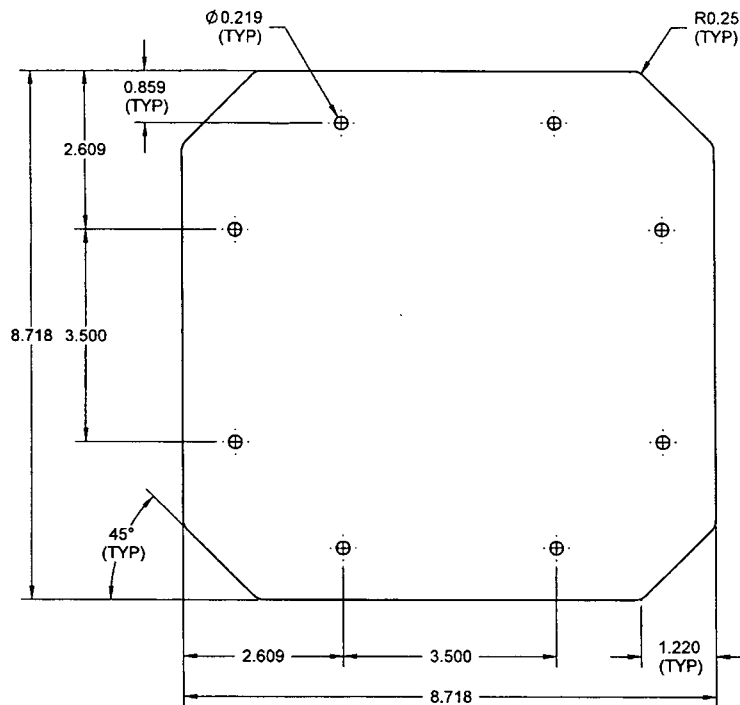
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DRAWN	JH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	SS	D3245	SHEET 4 OF 7
APPROVED	SS	TITLE	SCALE
DE APPR.	SS	ACCESS PANEL ASSEMBLY	1:2
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D3245-1F PANEL FLAT PATTERN

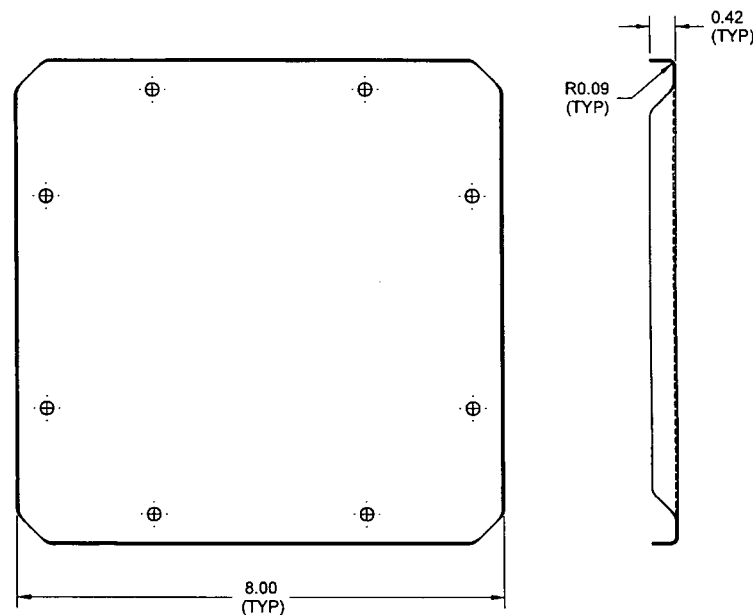
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10/10/23

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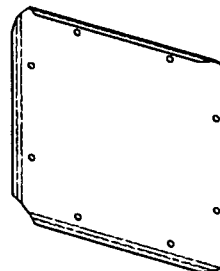
D3245-3F DOOR FLAT PATTERN



D3245-3 DOOR BENDING DETAIL

RELEASED
07-10-02

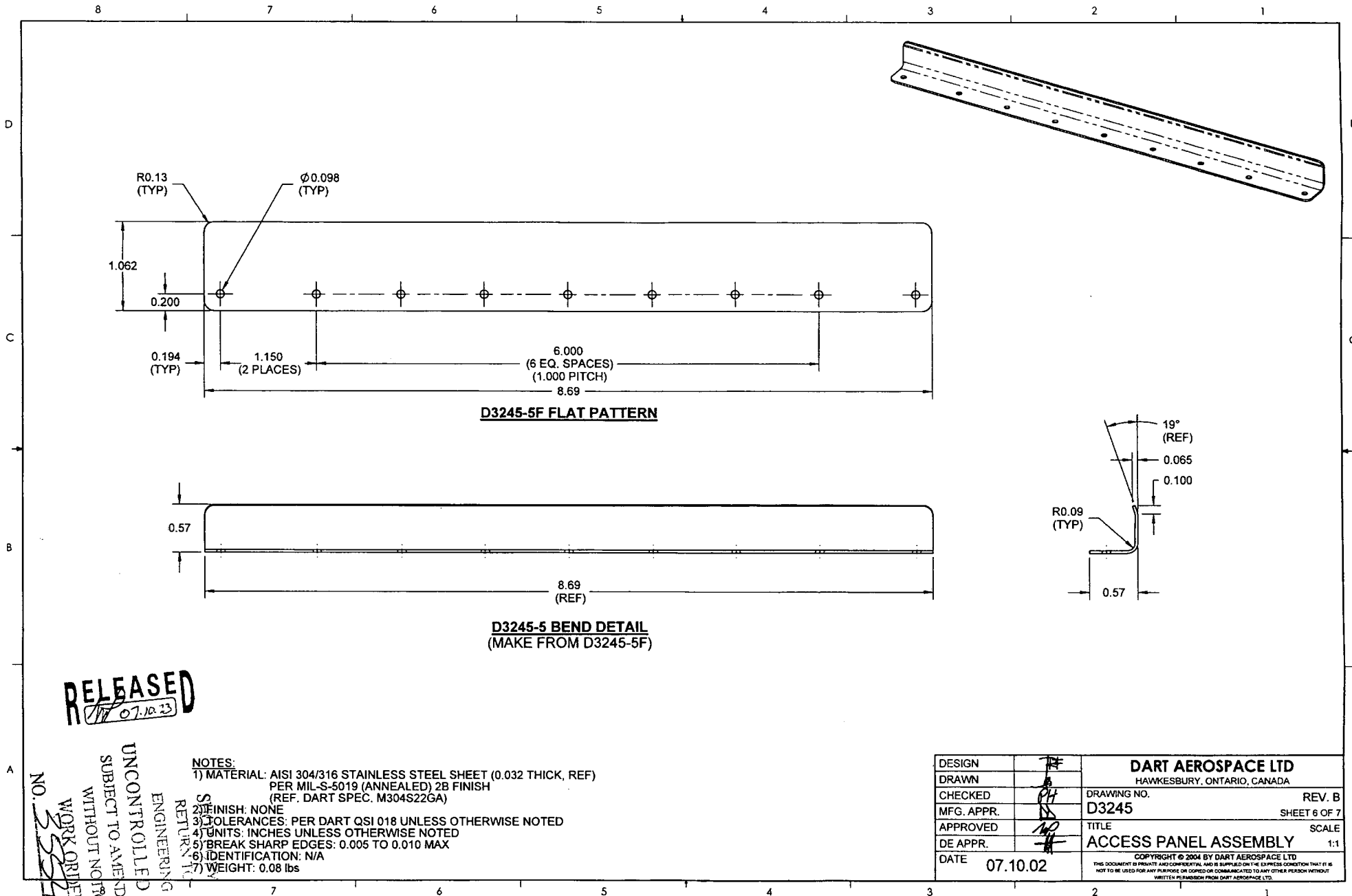
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
- WEIGHT: 0.67 lbs



DESIGN	PH	DART AEROSPACE LTD	
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MFG. APPR.	PH	D3245	SHEET 5 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY	
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7 6 5 4 3 2 1

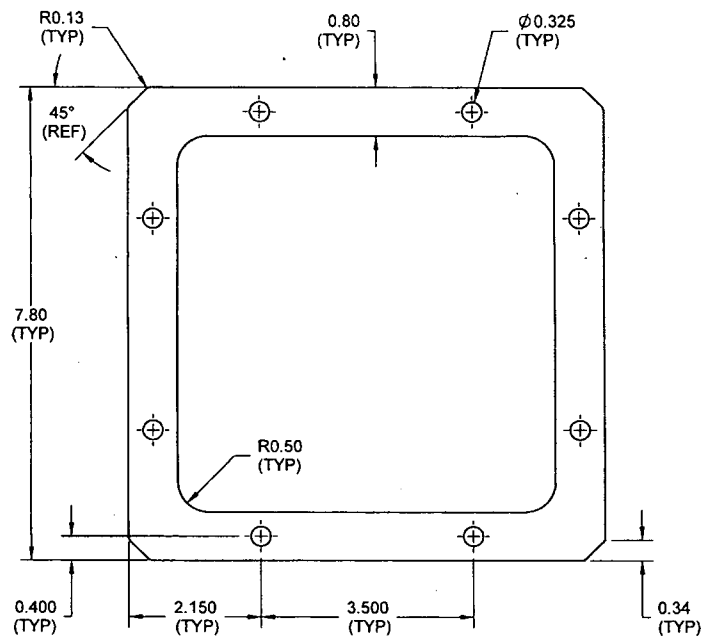


RELEASED
07.10.02

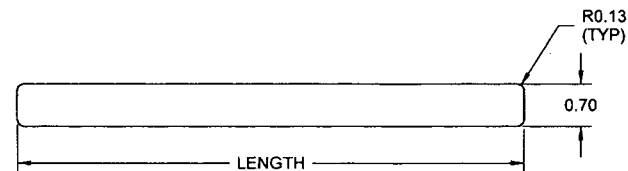
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WORK ORDER
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- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO.	REV. B
CHECKED	DS	D3245	SHEET 6 OF 7
MFG. APPR.	MD	TITLE	SCALE
APPROVED	MD	ACCESS PANEL ASSEMBLY	1:1
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DATE	07.10.02		



D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

RELEASED
07.10.03

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO.	REV. B
CHECKED	PH	D3245	SHEET 7 OF 7
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APPROVED	PH	ACCESS PANEL ASSEMBLY	1:2
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DATE	07.10.02		

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